

Work Order ID 77167 - 2
November-28-11 9:00:09 AM

77167

Soon

Item ID: D3779-041
Revision ID:
Item Name: Handle Assembly (Exterior)
Start Date: 28/11/2011 Start Qty: 4.00
Required Date: 12/12/2011 Req'd Qty: 4.00
Reference:

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: Process Plan: M.C.S Date: 11/12/28 Tooling:
QC: Date: SPC (Y/N):

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3779	Rev A								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3779								
(6-12-22)	Dwg Rev: A								
	Prog Rev: A								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

13 (1-12-22)

13 (1-12-22)

12/12/22

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77167

November-28-11 9:00:09 AM

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Page 2

Item ID: D3779-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Handle Assembly (Exterior)

Stop ***NS2***

Start Date: 28/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

1- counter sink holes as per dwg D3779
2- deburr

0.00

0.00

EB 11/12/22 (6)

140

140

QC

Quality Control

QC 5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8-11-13

(46)

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

11-12-23

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N9000040100

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NS1

Revision ID:

Item Name: Handle Assembly (Exterior)

Stop

NS2

Start Date: 28/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6x
count of 11/12/12

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003

SB 12/01/03

(2)

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

8/12/10/4

(x2)

Dart Aerospace Ltd

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Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

200

Identify as per dwg & Stock Location:

0.00

200

Packaging

Memo

PPP 77166

0.00

Packaging

12/01/05

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

CK 12/01/05

mf 12-01-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Print

November-28-11 9:00:14 AM

Page 1

Work Order ID: 77167

77167

Parent Item: D3779-041

D3779-041

Parent Item Name: Handle Assembly (Exterior)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-09 new issue DD verified by:ec
IPP Rev:B 08-07-21 procedure change DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		100	sf	84.7400	0.194	0.816842	1.5		
M6061T6S 125													
6061-T6 .125 Sheet													

Location	Loc Qty	Loc Code
MAT009	4.9	
119513	4.9	
MAT021	79.84	
113608	65.35	113608
118217	14.49	

D3203-1 Manufactured No

D3203-1

Handle

Location	Loc Qty	Loc Code
ST240	39	
65003	1	
69020	8	
73552	30	

MS20426AD10-8 Purchased No

MS20426AD10-8

Rivets

Location	Loc Qty	Loc Code
ST318	247	
109681	197	
110153	50	

M 108 110

SP 12/01/03

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

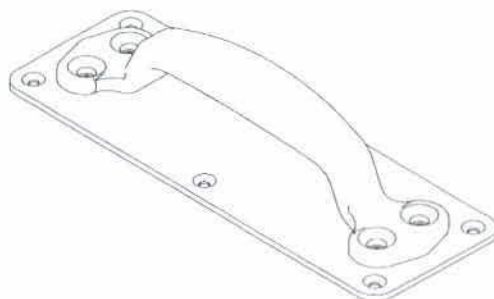
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

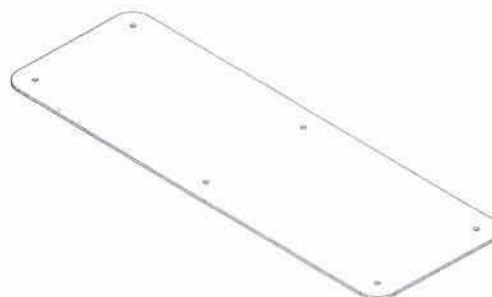
NOTE: Date & initial all entries

QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK

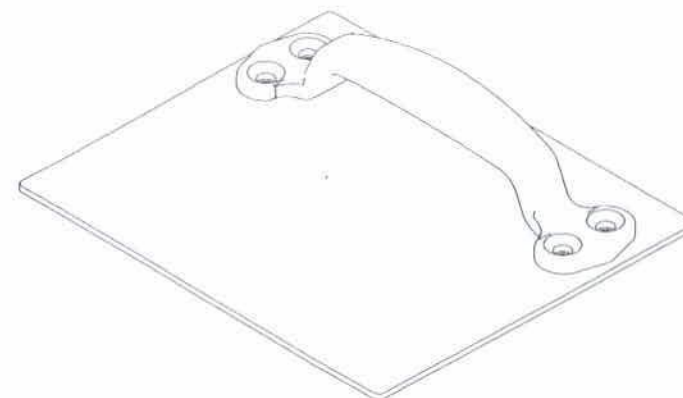
77169 M.L.S
11/1/78



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



D3779-3 DOUBLER PLATE



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

RELEASED
08.04.21

A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV A
MFG APPR		D3779	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

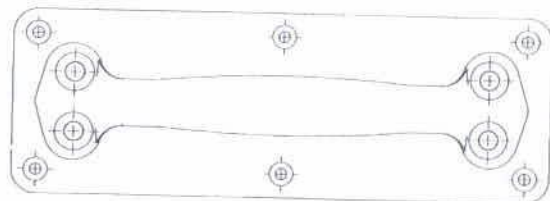
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

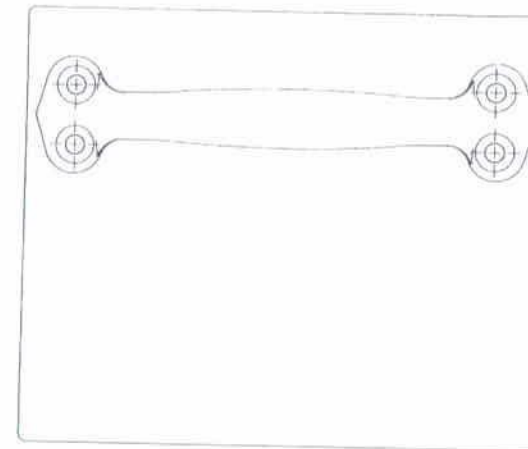
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

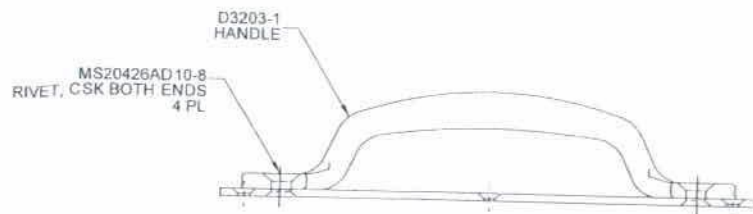
77147



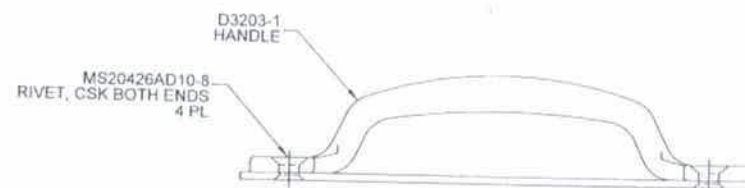
D3779-1
PLATE



D3779-5
PLATE



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

RELEASED
08-06-14

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3779	REV. A
MFG. APPR		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR	
APPROVED			
DE APPR		SCALE NTS	
DATE	08.04.21		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

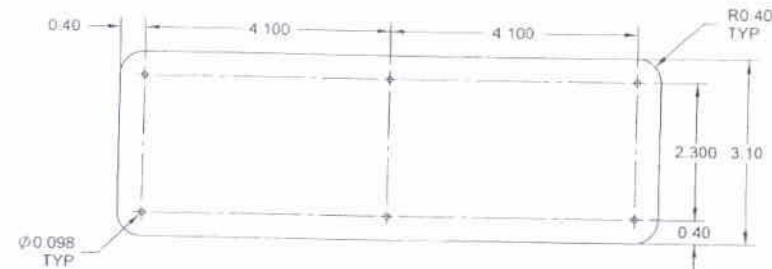
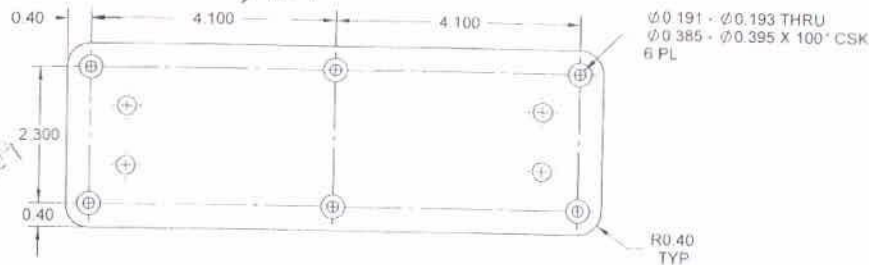
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77167



D3779-3 PLATE

D3779-1 PLATE

NOTES

1) MATERIAL -1 PLATE

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125

-3 PLATE

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED


4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER
(DO NOT IDENTIFY -1 & -5)

7) WEIGHT: 0.14 LBS FOR -3

RELEASED
03-05-2010

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR		D3779	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR		HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

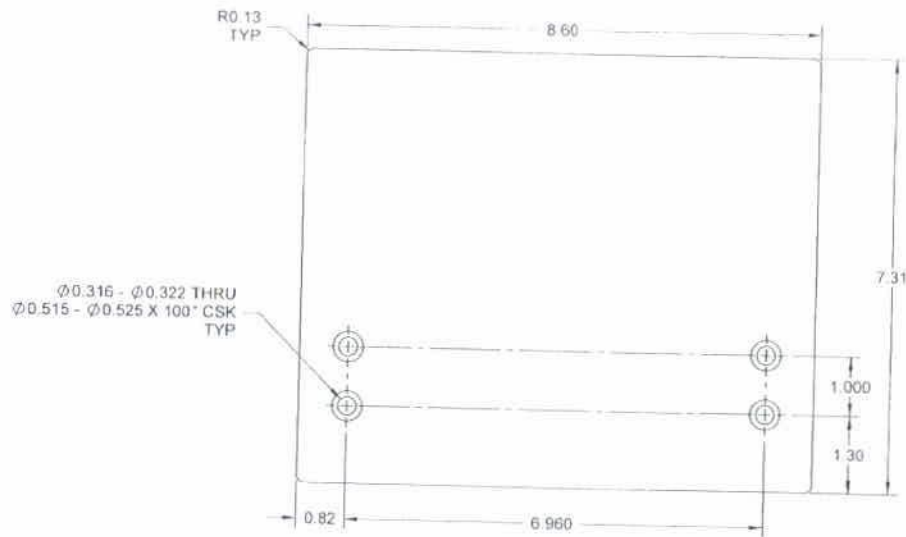
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77167



D3779-5 PLATE



NOTES:

- 1) MATERIAL: -5 PLATE
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M8061T6S 125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

RELEASED
08.04.21

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV A
MFG. APPR		D3779	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR		HANDLE ASSEMBLY	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Rev	Date	Change	New Issue
A			
Measured by: 12	Date: 11-10-22	Audited by: S	Date: 11/2/22
Prototype Approval:	Date:	Revised by: KJULM	Approved

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Ø	191	+0.05 - .001	.194	X		V	B.2
Ø	316	+0.06 - .001	.313	X		V	
	.40	±	.405	X		V	
	Ø300	±	Ø303	X		V	
	4.100	±	4.109	X		V	
	3.10	±	3.107	X		V	
	9.00	±	9.000	X		V	Plastic
	1.000	±	1.000	X		V	
	1.05	±	1.049	X		V	
	6.90	±	6.953	X		V	
	1.02	±	1.025	X		V	
	.105	±	.103	X		V	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Part Number: D3779-241	Work Order: 77167
Description: HAN D-E ASS	Inspection Dwg: D3779-1 Rev: 1
Page 1 of 1	

W/O:		WORK ORDER CHANGES					
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